

which carries the fourth locating pin, is pivoted to the base of the fixture and provided with a lug which enters an opening through the base and receives the pressure of the spring plunger *F*. The brackets *G* are attached to the base of the fixture and the cover-plate is hinged to these brackets. The brackets are also bored out to receive two spring plungers. The operating lever is fastened to a hub *H* and a link *I* is pivoted on this hub, the opposite end of the link being attached to the hub *J*. The screws which hold the operating lever to the hub *H*, and the link *I* to the hub *J*, are extended to form pins which engage the levers *K*.

The jig is shown closed with all parts in the positions they would occupy when holding a piece of work. To raise the cover-plate, the latch is pressed back, when the thrust of a spring plunger raises it sufficiently to prevent the latch reengaging the cover-plate. The cover-plate is raised to the limit of its movement which is a few degrees beyond the perpendicular. The operating lever is then swung to the left until it strikes a limit pin. This movement of the lever turns the hubs *H* and *I*, bringing the pins against the tail ends of the levers *K* and compressing the springs behind the plungers carried in the brackets *G*. Thus, the ends of the levers *K* which engage the work are swung back, releasing their grip. The final movement of the left-hand lever *K* brings the adjustable stop-screw *L* carried by this lever against a lug projecting above the lever *E*, thus compressing the spring *P* and releasing the work from the pressure of the pin carried by the lever *E*. The screw *L* limits the movement of the lever *E* to the minimum amount necessary to release the work, and the stop-screw may be adjusted to accomplish this after the jig has been locked open. After removing the work from the jig, an undrilled piece is placed in position and the operating lever thrown to the right. This causes the different holding members to go through their sequence of movements in the opposite order to that described for releasing the work from the jig. The result is that the work is clamped in place in a amount of time.